

SPUT

Dart Aerospace Ltd.

Date: Tuesday, 7/10/2007 1:05:54 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPAD
Job Number	: 33457	Part Number	: D35649
Estimate Number	: 12784	Drawing Number	: D3564 REV C
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 7/10/2007 S.O. No. : N/A	Drawing Revision	: C
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A	Due Date	: 7/17/2007
Previous Run	: N/A	Qty:	30 Unit Each
Written By	: [Signature]		
Checked & Approved By	: [Signature] 07.07.10		
Comment	: Est Rev:A New Issue 07-03-08 ec Est Rev:B As per Rev C 07-07-09 JLM		

Additional Product

Job Number:



Seq. #.	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 .063 Sheet
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Comment: Qty: 0.9177 sf(s)/Unit Total: 27.5310 sf(s)

M304S16GA Stainless steel sheet 0.063" thick

Batch: M104735

IB 07-07-16

M102961

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3564 ***** (D3564-1F)*****

Dwg Rev: C

Prog Rev: C

2-Debur if necessary

IB 07-07-16

30 + 1

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

IB 07-07-16

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SA 07/07/17

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

Debur if necessary

Form on Brake as per Dwg D3564 using Jigs DT

and DT

SAO 07/07/17

Form Joggle as per Dwg D3564 on brake using Jig DT

SAO 07/07/17

31

31

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 33457

Part Number: D35649

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

Er 07/07/17 (x3)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description

A/R 2059B Hardcoat

Batch

M105258

88 07/07/25 (3x)

Weld hardcoat as per Dwg D3437

8.0

QC5

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07-07-25 (3)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-07-25 (3)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M 104846

BK/Fd 07-07-26 (3)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-F 07/07/26 (2x)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

used all 3 for tubes.

Fd 07/07/26 (3)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



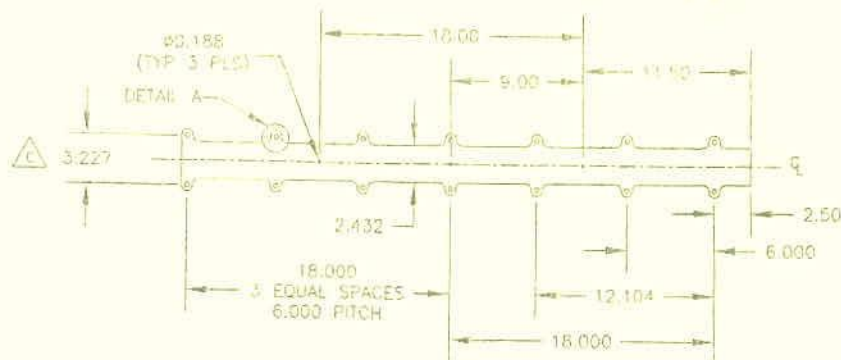
Comment: FINAL INSPECTION/W/O RELEASE

07/07/27 (3)

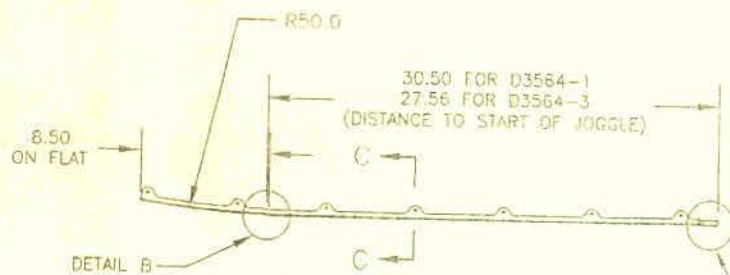
Job Completion



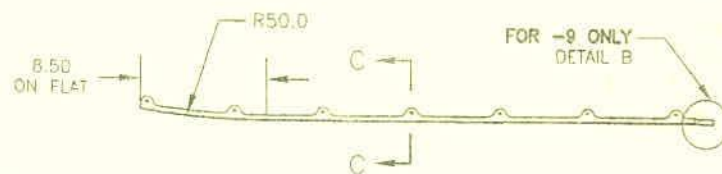
U 07-07-27



D3564-1F FLAT PATTERN



D3564-1/-3 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-9/-11 BENDING DETAIL
(MAKE FROM D3564-1F)

2059B HARDCOAT WELD
4.0 LONG
0.063 TO 0.125 HIGH
(TYP. 11 PLS.)
WELD AFTER BENDING AS
ILLUSTRATED PER DTB308



D3564-1/-3/-9/-11 WELDING DETAIL

RELEASED
07.06.28

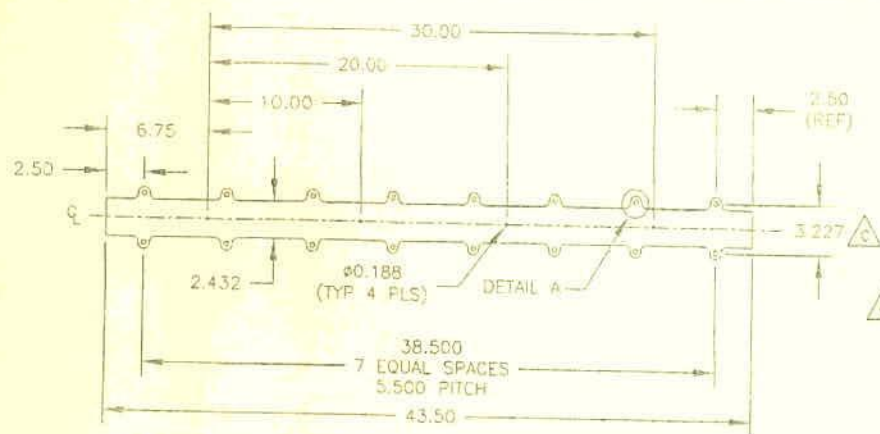
D3564-1/-3/-5/-7/-9/-11/-13 WEARPLATE NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005-4.3
- 3) WELD PER DART QSI 004
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 7) PART IS SYMMETRICAL ABOUT CENTERLINE

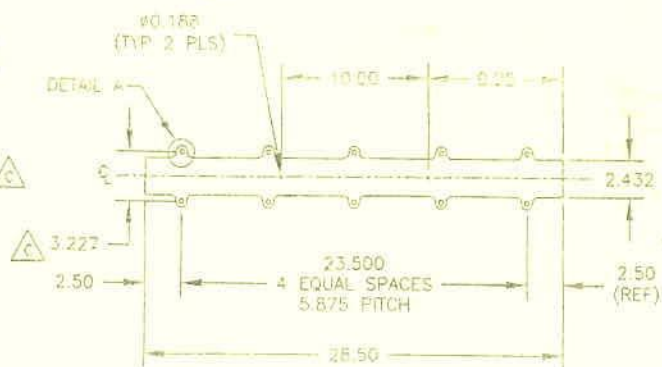
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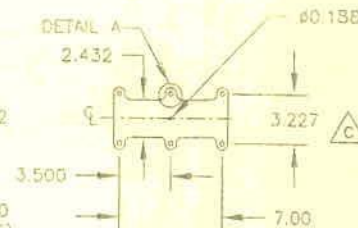
C	07.04.17	MOVE TAB OUTBOARD, DETAIL A
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.12.18	NEW ISSUE
DESIGN	DRAWN BY	DART
CHECKED	APPROVED	DART AEROSPACE LTD.
DATE	REV	D3564
07.04.17	WEARPLATE	SHEET 1 OF 2



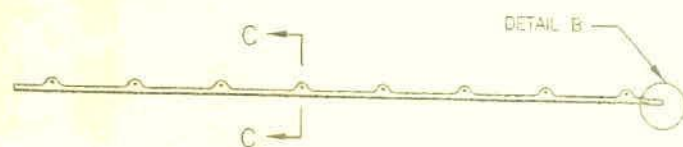
D3564-5F FLAT PATTERN



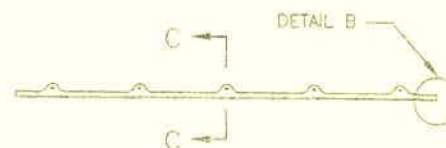
D3564-7F FLAT PATTERN



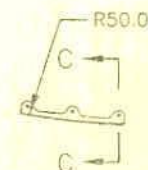
D3564-13F FLAT PATTERN



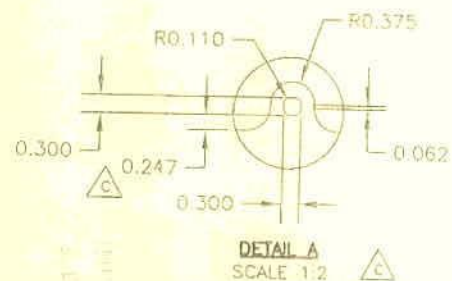
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



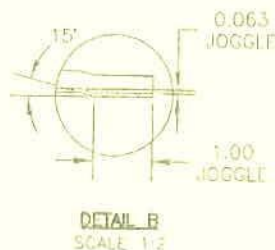
D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



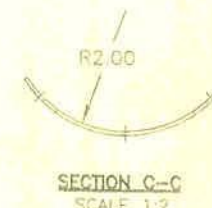
D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



DETAIL A
SCALE 1:2



DETAIL B
SCALE 1:2



SECTION C-C
SCALE 1:2

RELEASED
07.06.28.17

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	DATE: 07.04.17	REV: WTAD/SIDE	SCALE: 1:5

DART AEROSPACE LTD		Work Order:	33457
Description: WEAR PAD		Part Number:	D3542
Inspection Dwg:	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

Measured by: HB	Audited by: En	Prototype Approval:
Date: 07-07-16	Date: 07/07/17	Date:

Rev	Date	Change	Revised by	Approve
A		New Issue	KJ/RF	

